

Nanotechnology Corrosion Pretreatment for Magnesium Alloys

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29 August 2012

Report Documentation Page				Form Approved OMB No. 0704-0188	
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1. REPORT DATE 29 AUG 2012		2. REPORT TYPE		3. DATES COVERED 00-00-2012 to 00-00-2012	
4. TITLE AND SUBTITLE Nanotechnology Corrosion Pretreatment for Magnesium Alloys				5a. CONTRACT NUMBER	
				5b. GRANT NUMBER	
				5c. PROGRAM ELEMENT NUMBER	
6. AUTHOR(S)				5d. PROJECT NUMBER	
				5e. TASK NUMBER	
				5f. WORK UNIT NUMBER	
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES) Army Research Development and Engineering Center,Picatinny Arsenal,NJ,07806				8. PERFORMING ORGANIZATION REPORT NUMBER	
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)				10. SPONSOR/MONITOR'S ACRONYM(S)	
				11. SPONSOR/MONITOR'S REPORT NUMBER(S)	
12. DISTRIBUTION/AVAILABILITY STATEMENT Approved for public release; distribution unlimited					
13. SUPPLEMENTARY NOTES ASETSDefense 2012: Sustainable Surface Engineering for Aerospace and Defense Workshop, August 27-30, 2012, San Diego, CA. Sponsored by SERDP/ESTCP.					
14. ABSTRACT					
15. SUBJECT TERMS					
16. SECURITY CLASSIFICATION OF:			17. LIMITATION OF ABSTRACT Same as Report (SAR)	18. NUMBER OF PAGES 26	19a. NAME OF RESPONSIBLE PERSON
a. REPORT unclassified	b. ABSTRACT unclassified	c. THIS PAGE unclassified			

Program Objective:

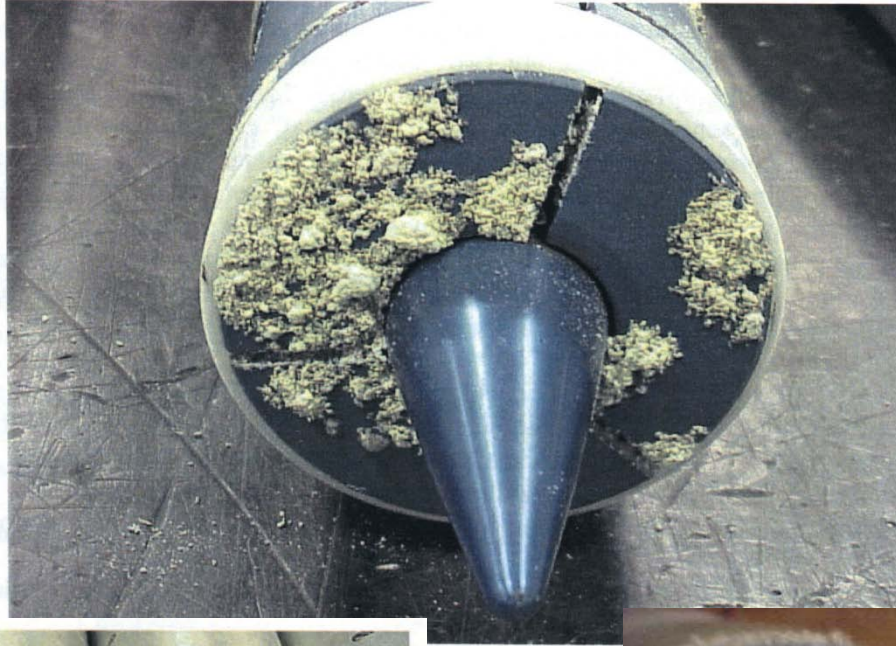


- Enhance corrosion resistance of lightweight magnesium alloys using novel chromate (hexavalent chromium (Cr^{6+})) free self-healing pretreatments

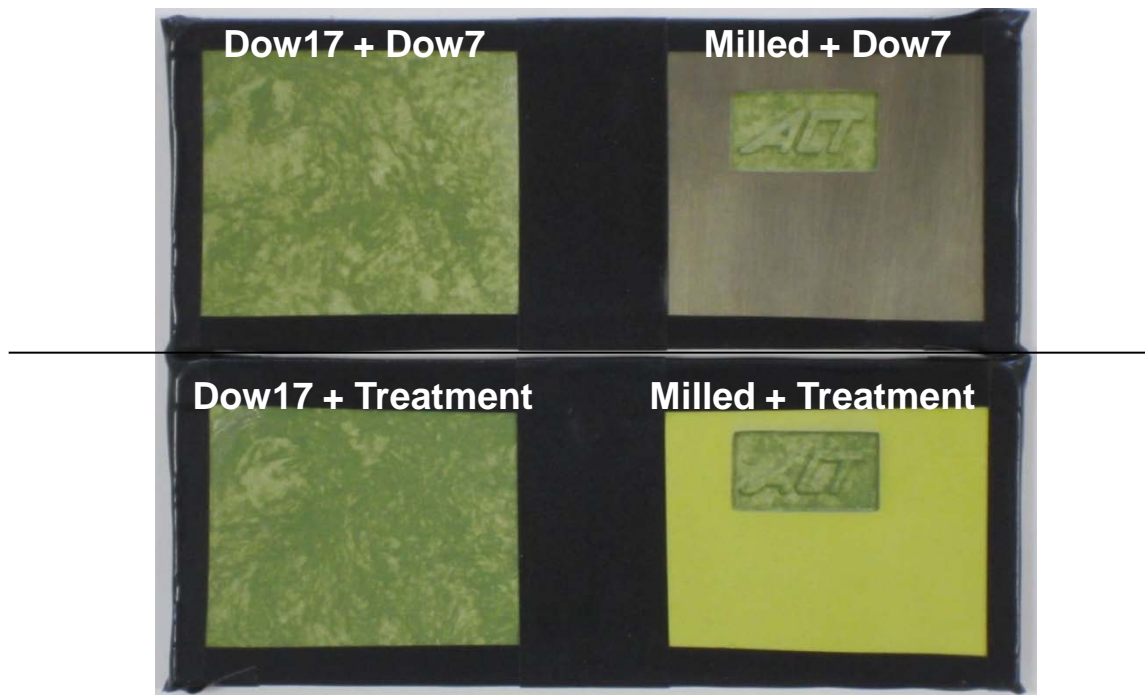
Potential Army Benefits



- Reduction in the environmental, health, and safety hazards associated with exposure to Cr^{6+}
- Compliance with Under Secretary of Defense for AT&L's memo on hexavalent chromium reduction
- Enhanced corrosion resistance and "paintability" of lightweight alloys
- Decreased commodity weights through use of magnesium as replacements for aluminum and steel



0 hr SST*



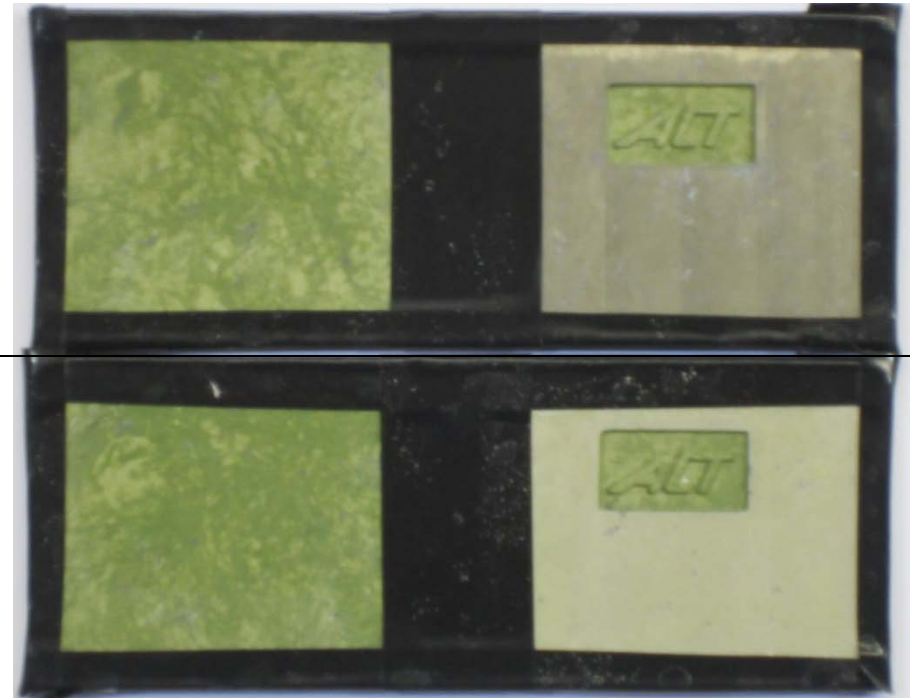
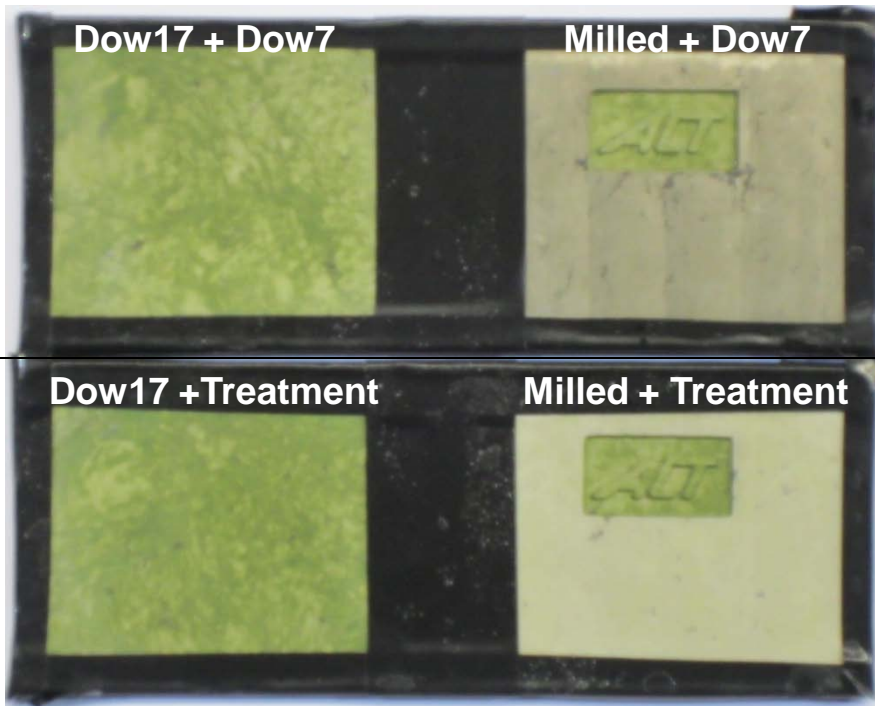
Dow7 (Chromium Conversion Coating) vs. Treatment over Dow17 (Chromium Anodized Coating) and Milled AZ91D

* SST=ASTM B117 Salt Spray Test *TECHNOLOGY DRIVEN. WARFIGHTER FOCUSED.*

24h SST

Wet

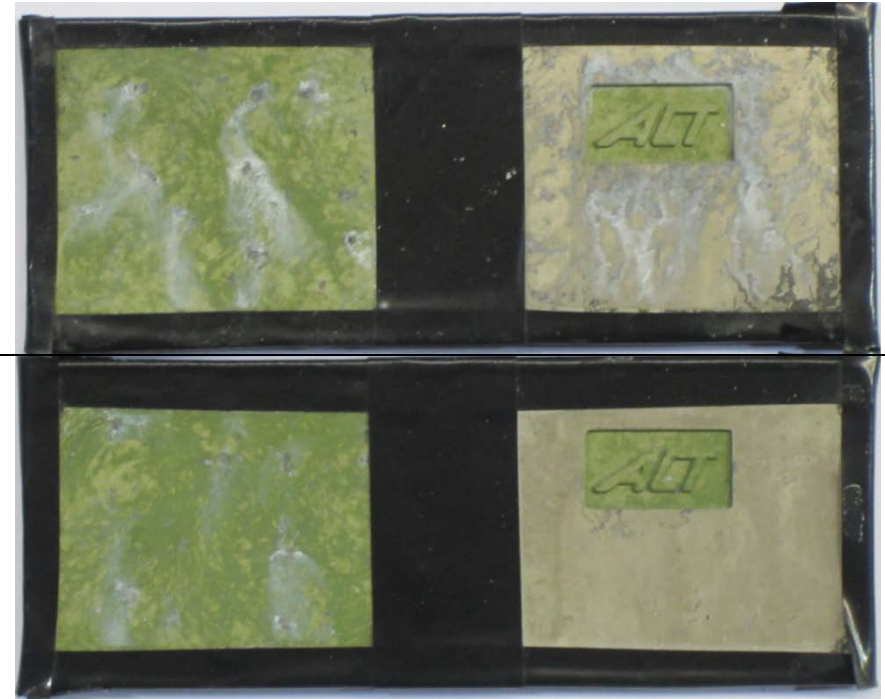
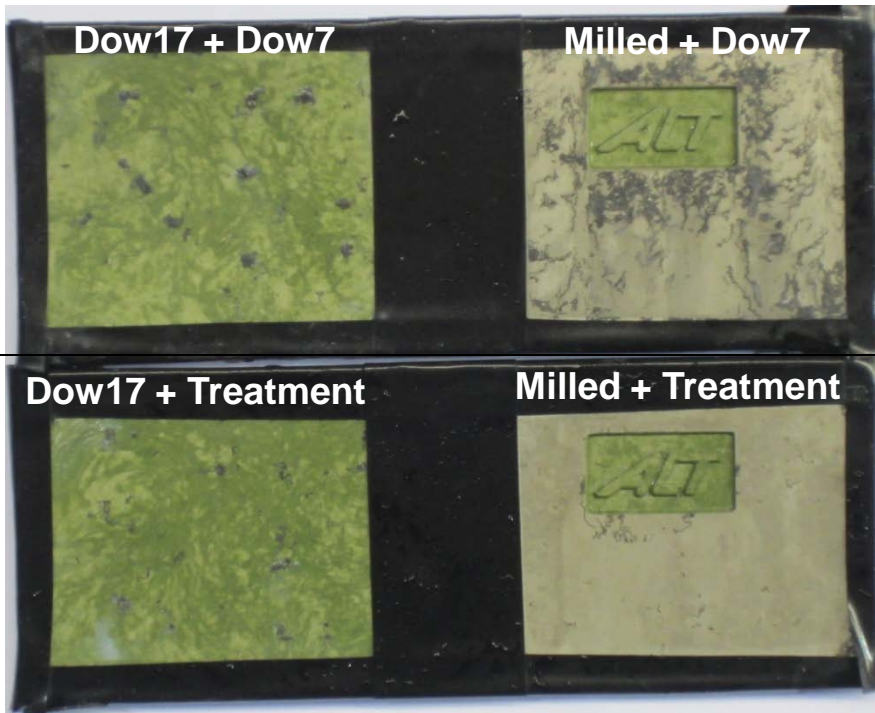
Dry



168 hrs SST

Wet

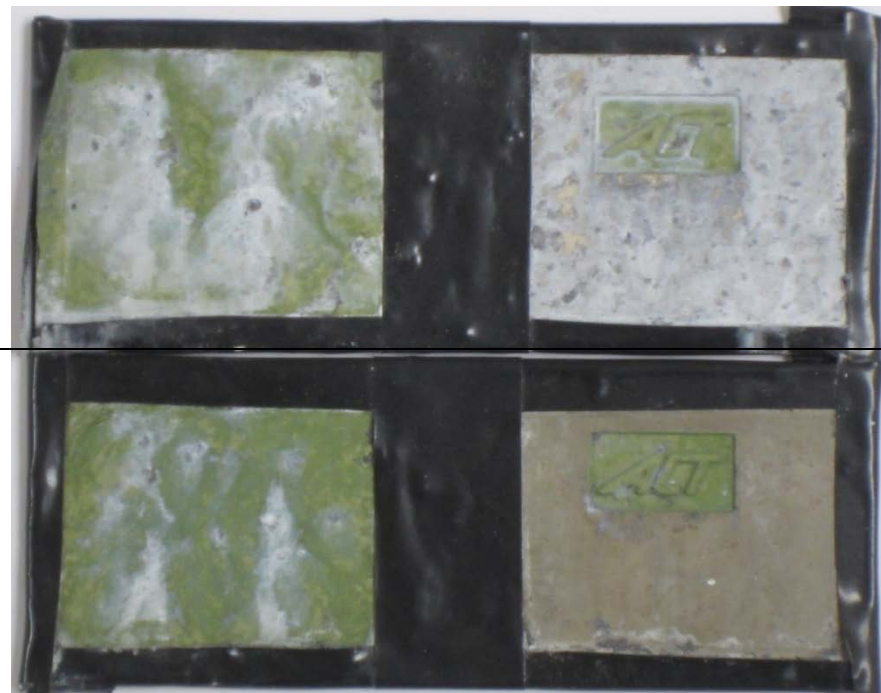
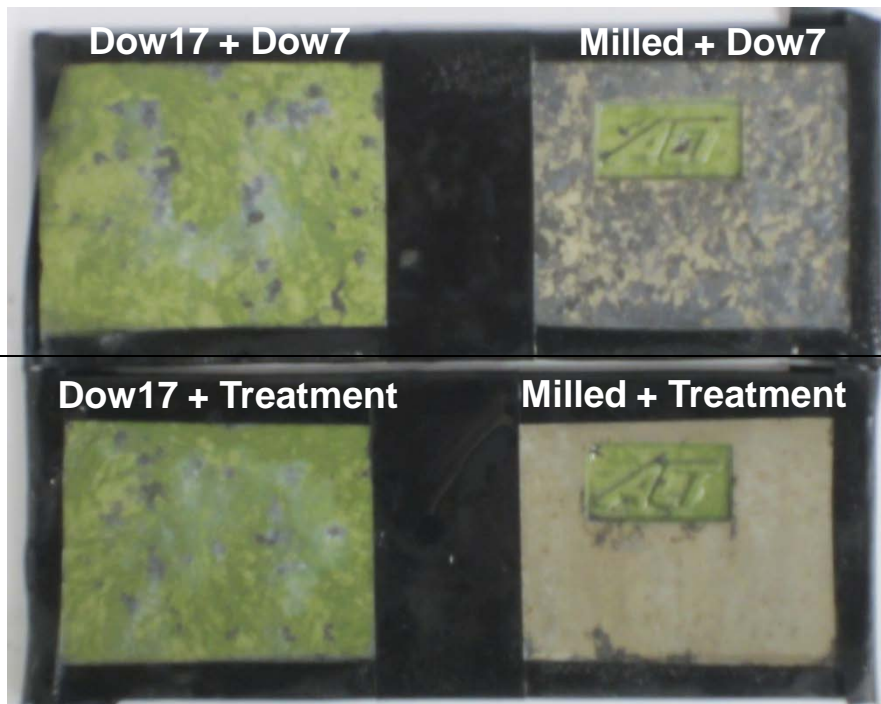
Dry



504 hrs SST

Wet

Dry



Samples for Salt-Spray Test (ASTM B117 SST)

0 hr SST

Dow17
(Chromium
based anodized
coating)



Milled

Dow17 +
Treatment
(Chromium free
conversion
coating)

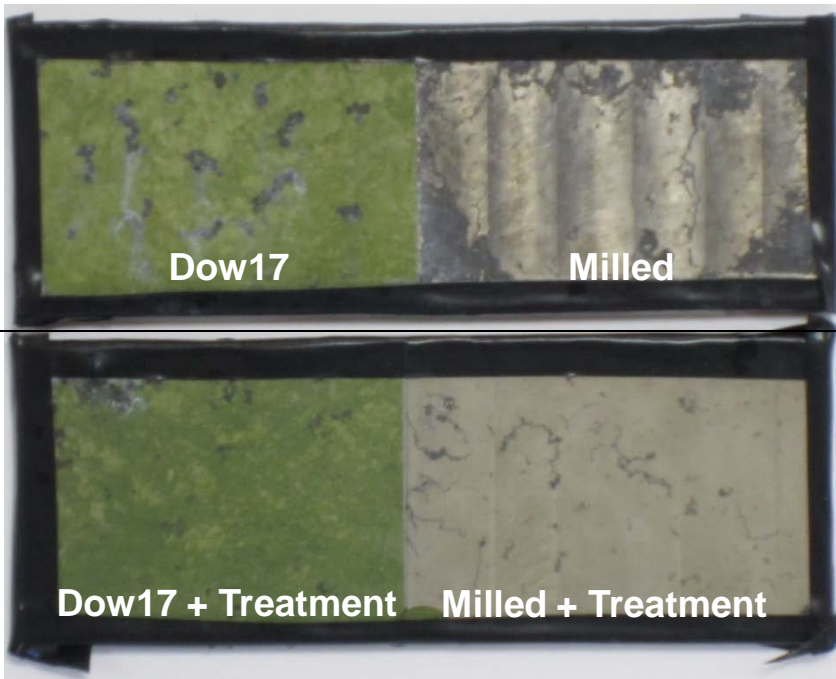


Milled +
Treatment

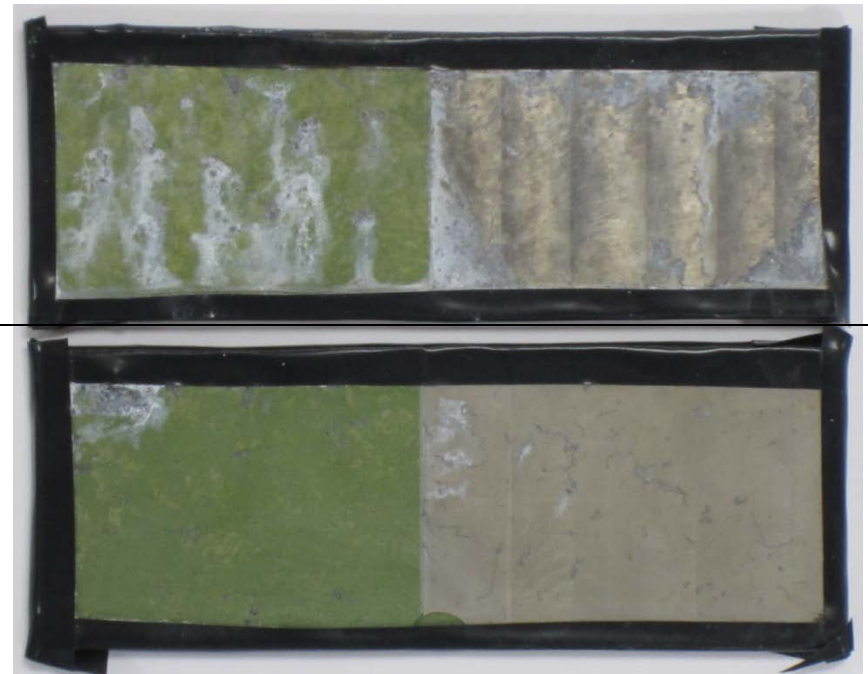
Mg AZ91D

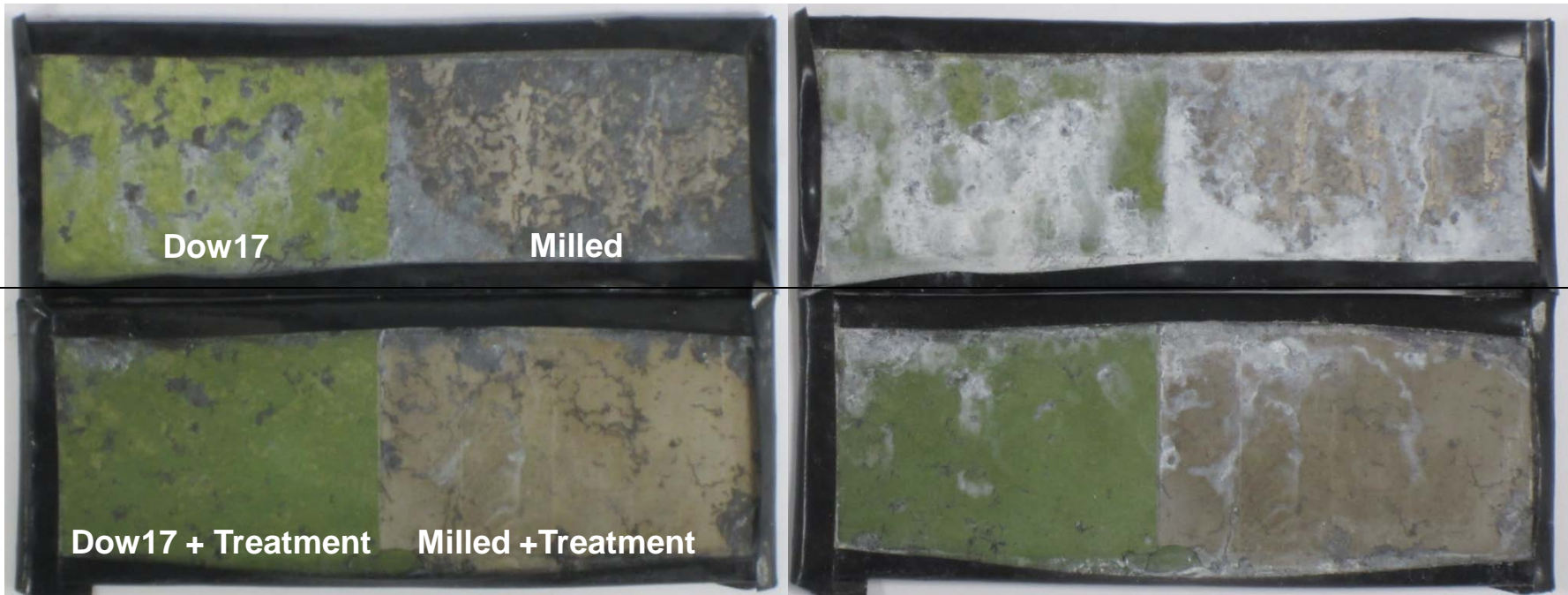
168 hrs SST

Wet



Dry

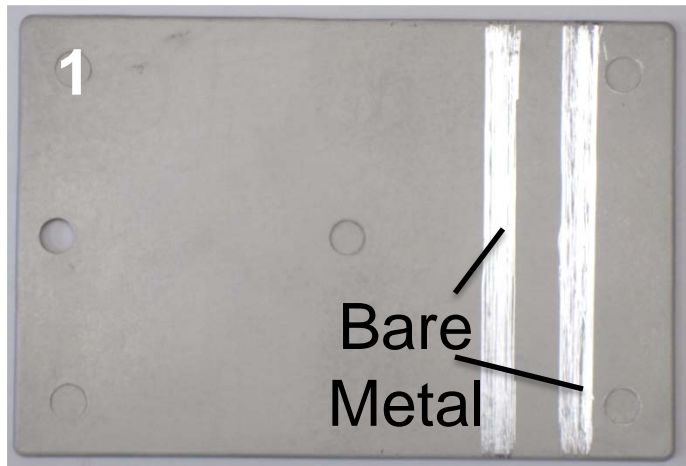


768 hrs SST**Wet****Dry**

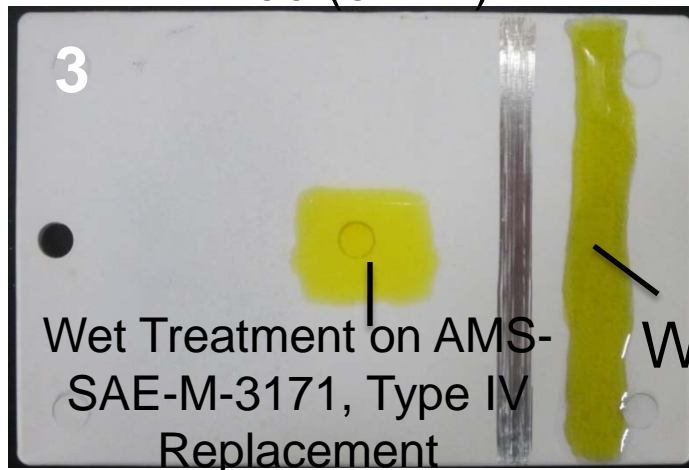
Compare the corrosion observed on Dow17 surface with the Dow17 + Treatment

Note the corrosion on Milled surface and the Milled + Treatment as well as Dow17 and Milled + Treatment

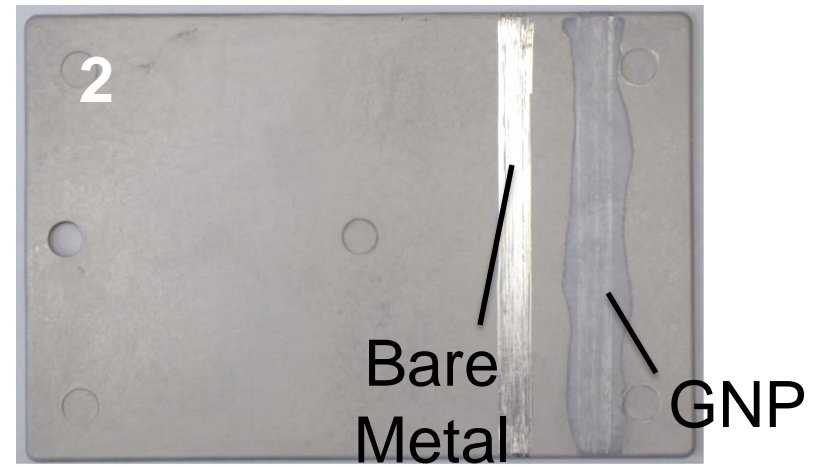
AMS-SAE-M-3171, Type IV Replacement on AZ91D



PT-60 (3 min)



Glycolic Nitrate Pickle (GNP) (1 min)



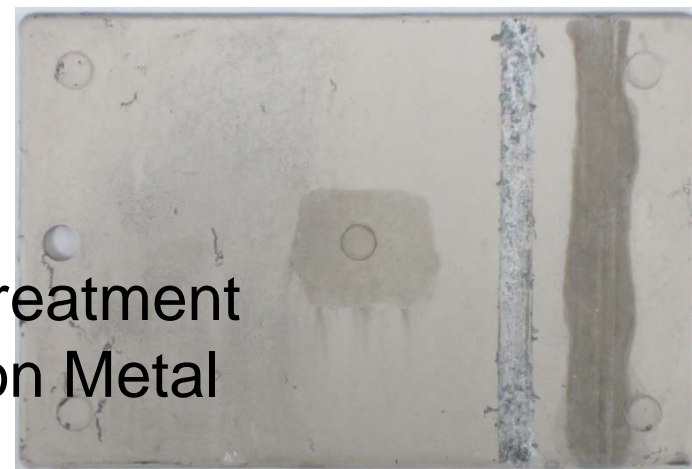
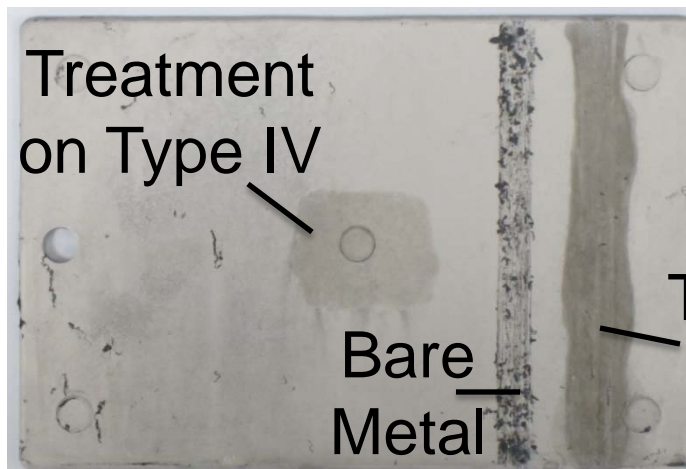
0 hr SST



Wet

Dry

**24 hrs
SST**



**168 hrs
SST**



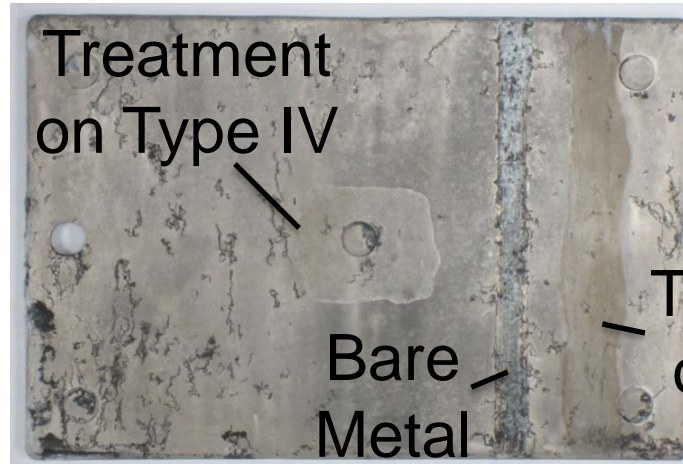
AMS-SAE-M-3171, Type IV Replacement = Type IV

TECHNOLOGY DRIVEN. WARFIGHTER FOCUSED.

Wet

Dry

336h SST



504h SST



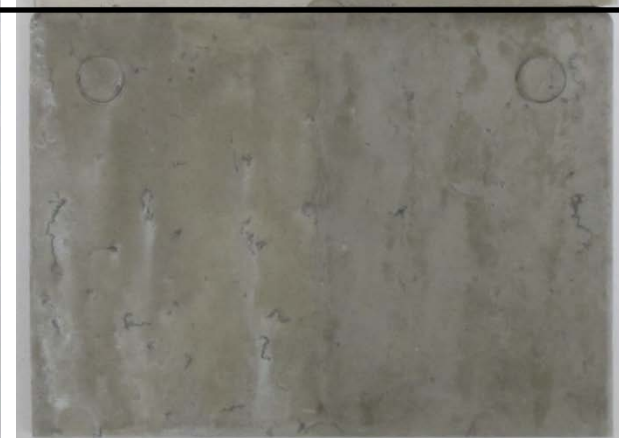
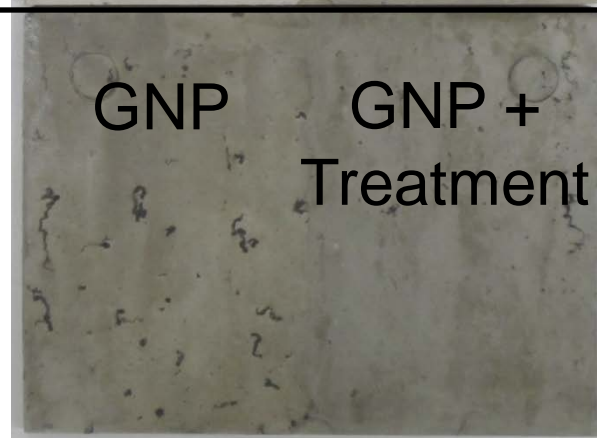
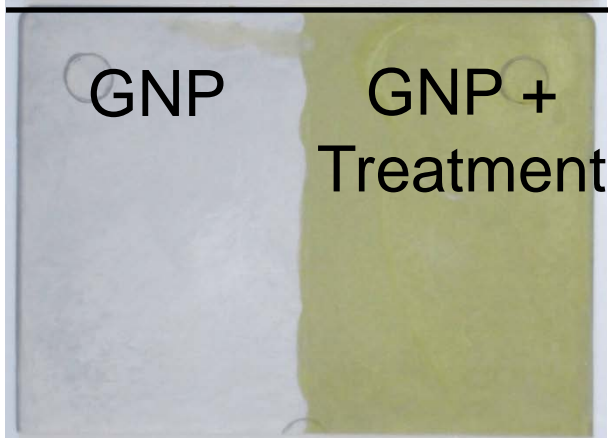
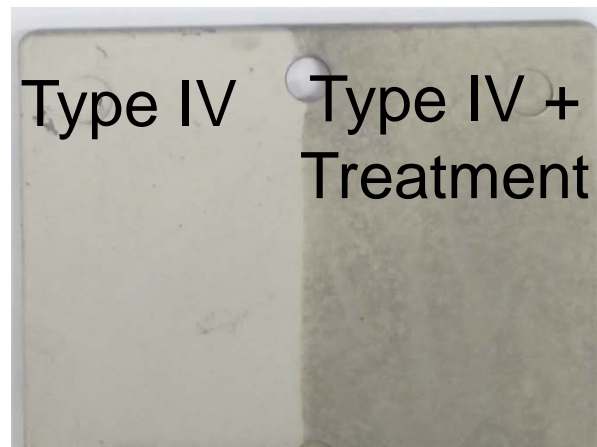
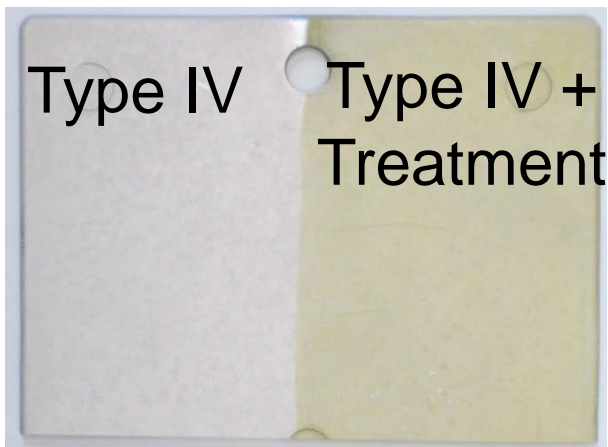
AMS-SAE-M-3171, Type IV Replacement = Type IV

0 hr SST

24 hrs SST

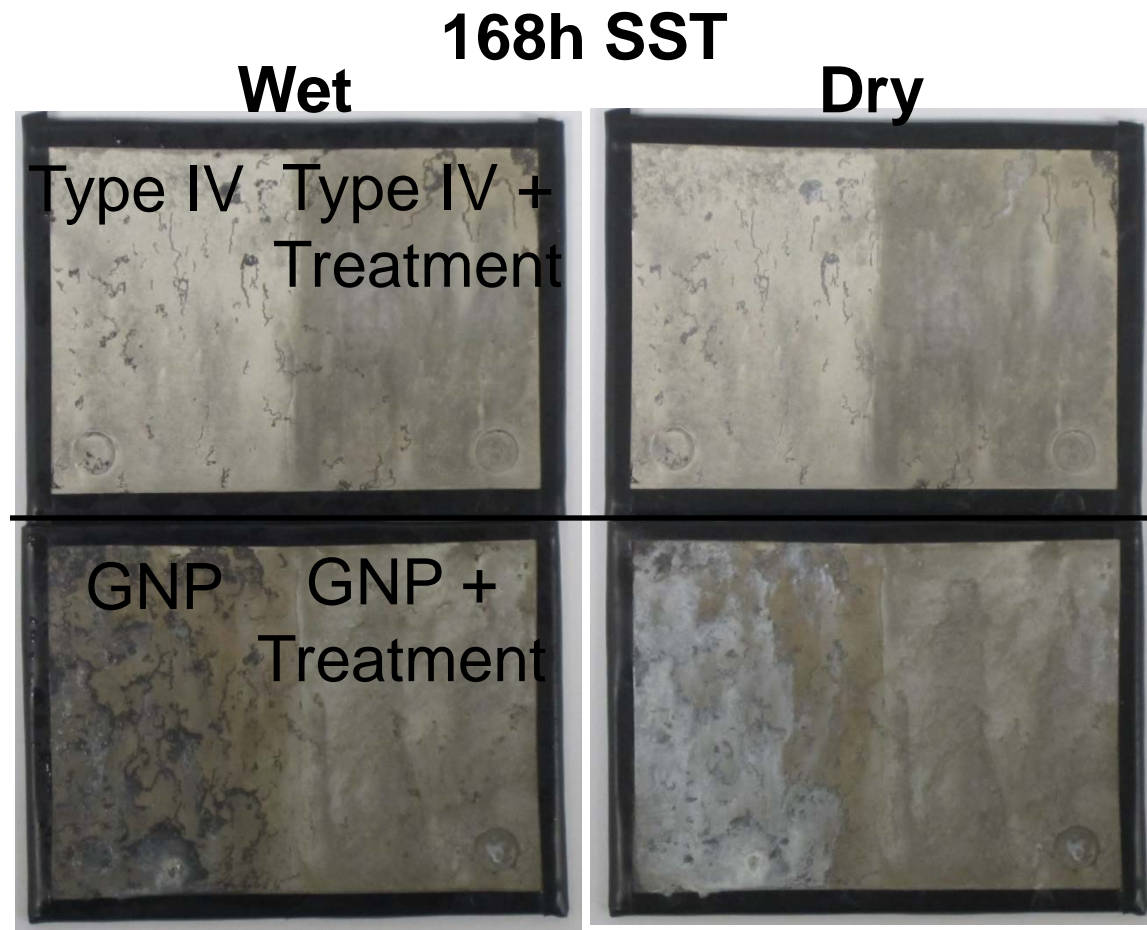
Wet

Dry



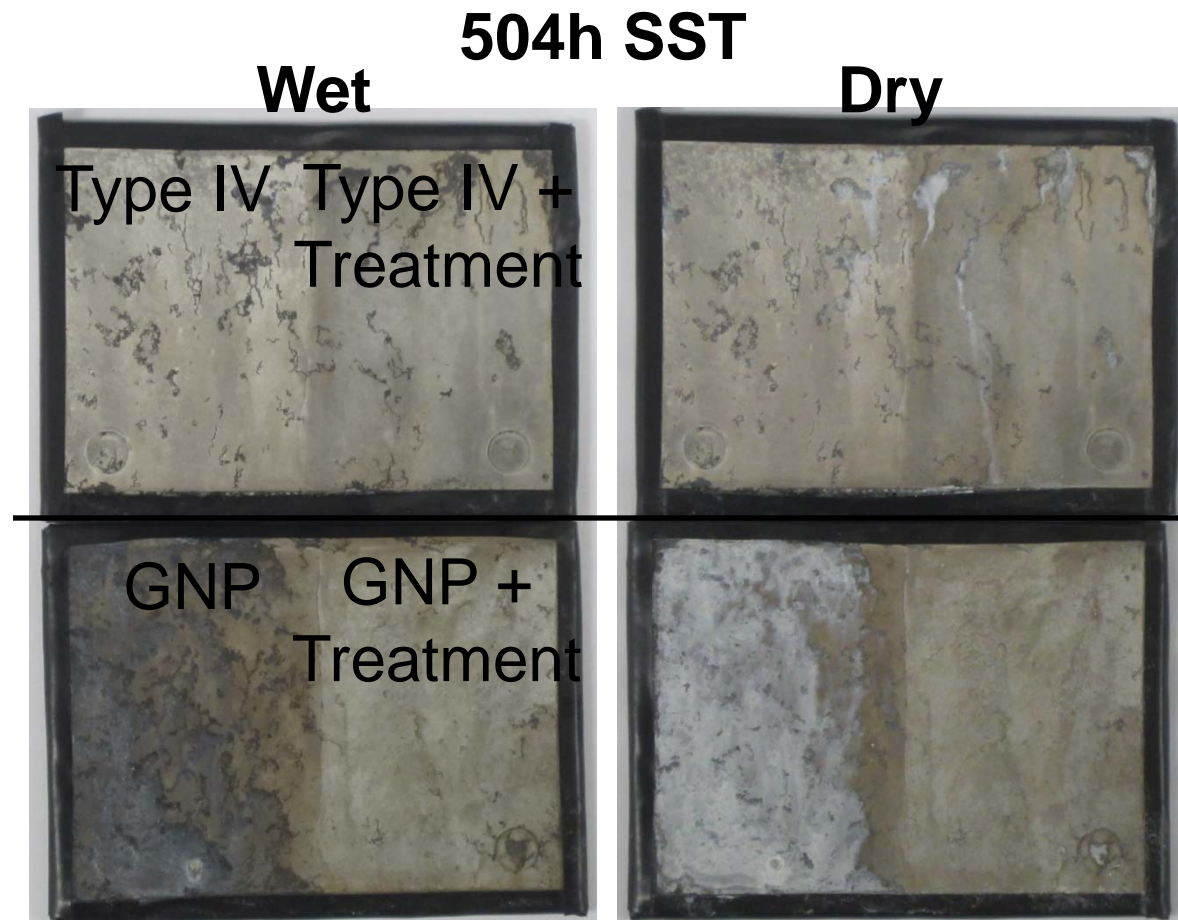
AMS-SAE-M-3171, Type IV Replacement = Type IV

TECHNOLOGY DRIVEN. WARFIGHTER FOCUSED.



AMS-SAE-M-3171, Type IV Replacement = Type IV

TECHNOLOGY DRIVEN. WARFIGHTER FOCUSED.



AMS-SAE-M-3171, Type IV Replacement = Type IV

TECHNOLOGY DRIVEN. WARFIGHTER FOCUSED.

AZ91D Panels

Mil Spec Primer

Auto Primer

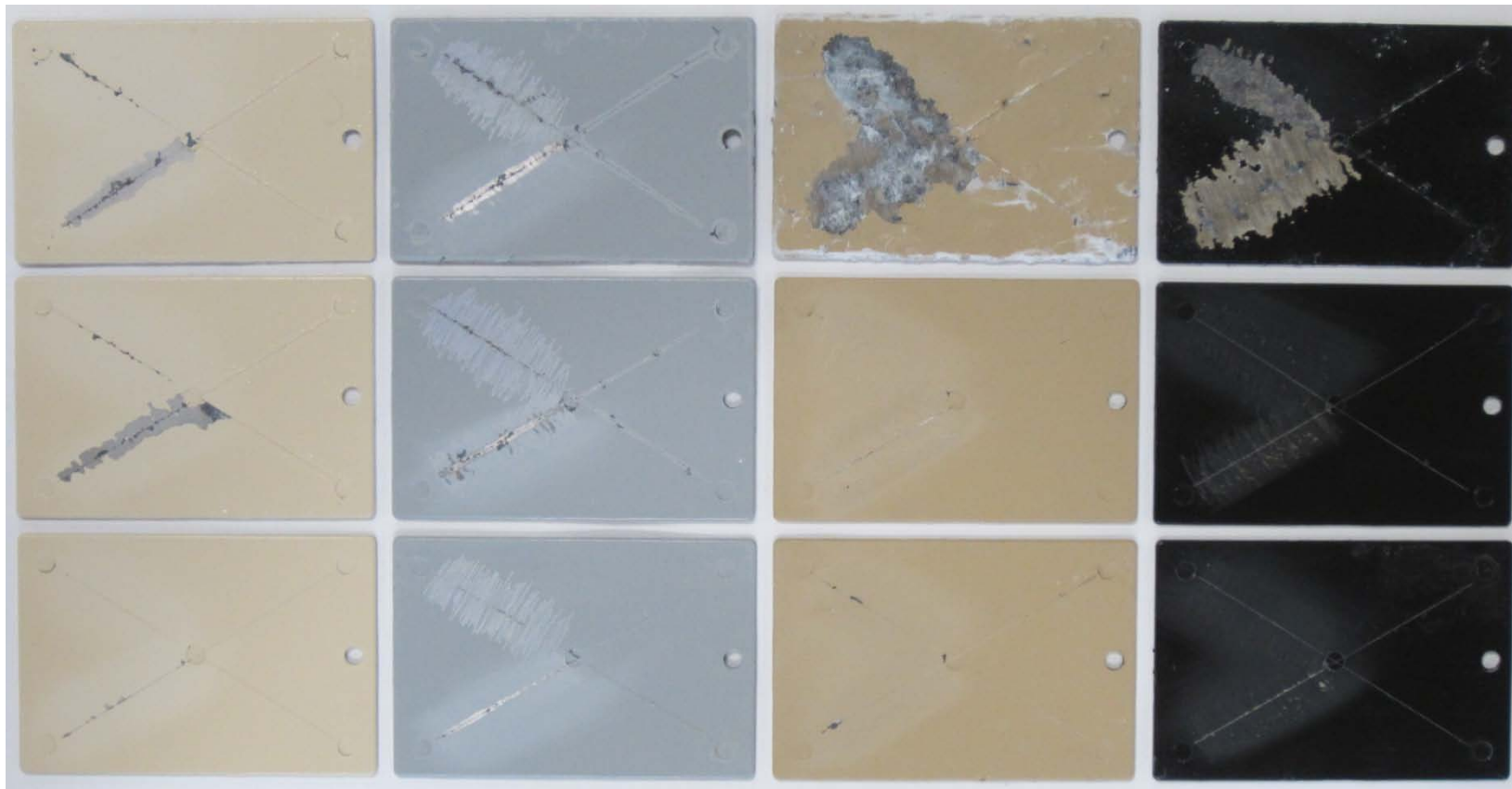
Powder Coat

E-Coat

Bare

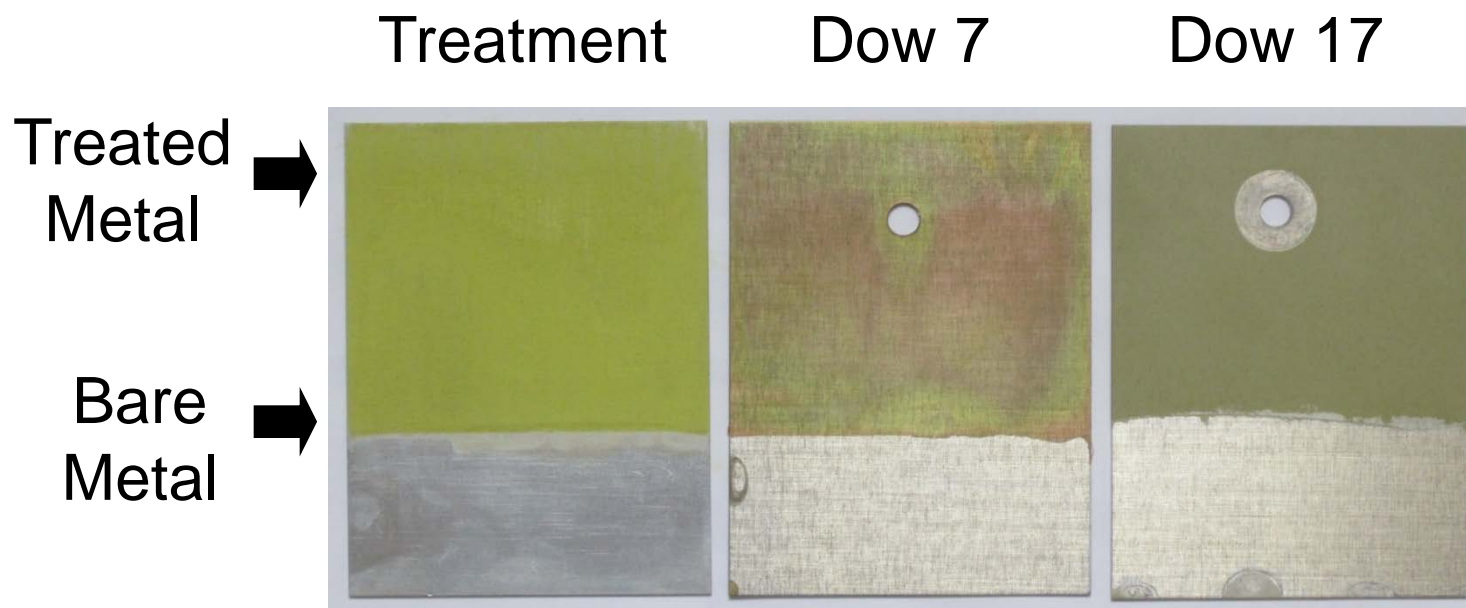
Dow 7

Treatment



Bare and pretreated Mg AZ91D panels painted and scribed, then exposed to salt-spray test (SST). Scribe scraped after 500 hrs (upper-left limb) and after 1000 hrs (lower-left limb) exposure to salt spray.

Mg AZ31B : 0 hr SST



Mg AZ31B : 24 hrs SST

Treatment

Dow 7

Dow 17

Wet



Dry



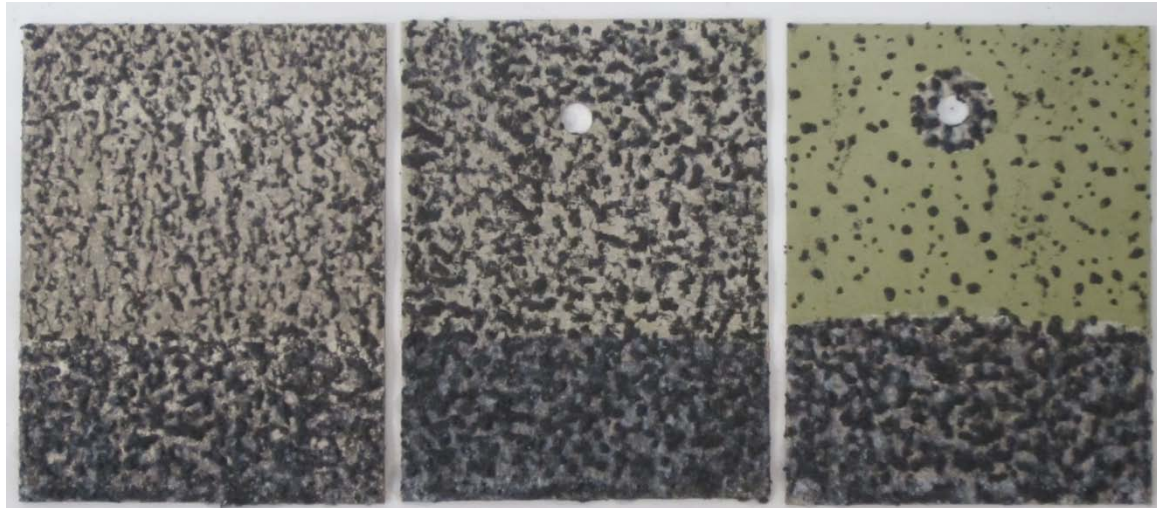
Mg AZ31B : 48 hrs SST

Treatment

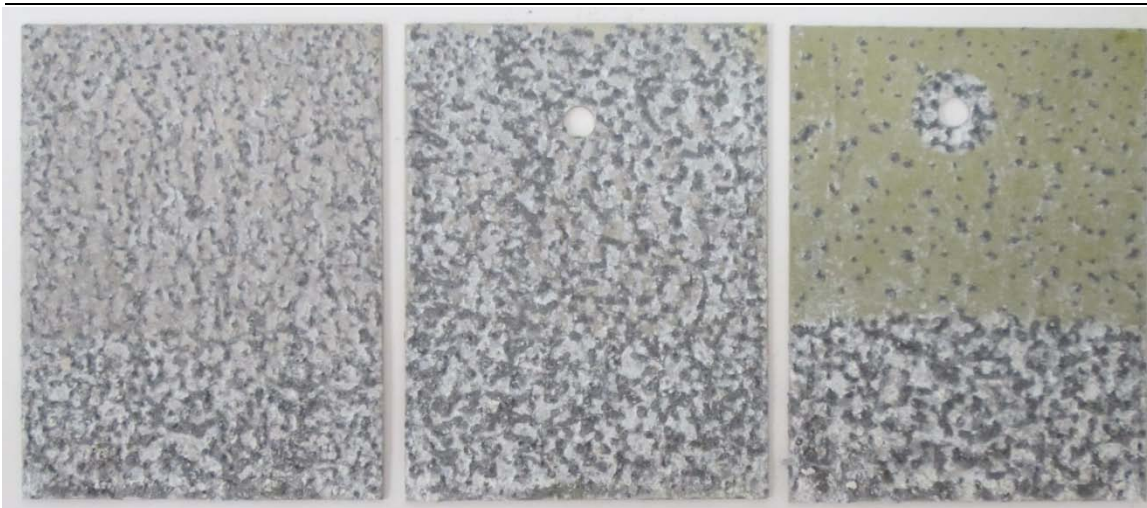
Dow 7

Dow 17

Wet



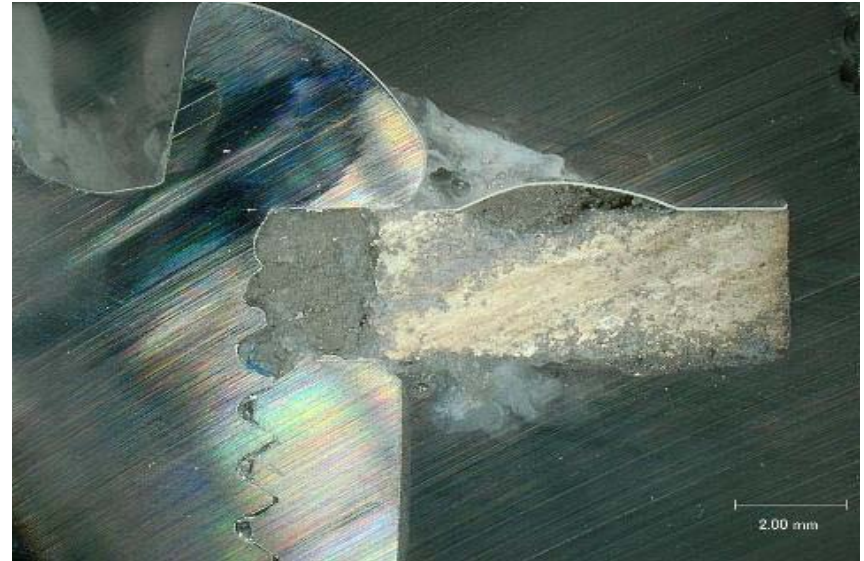
Dry



Zinc Plated Steel Nut and Bolt through AZ91D Panels



Dow7 with epoxy Primer



Treatment with epoxy Primer

Results/Conclusions

- Treatment (Cr^{6+} free) can be applied easily by brush or immersion application
- Treatment (performs at minimum) comparable to Dow7 on alloys tested with or without subsequent primer coating
- Treatment compatible with Dow7, Dow17 and AMS-SAE-M-3171, Type IV Replacement
- Treatment is capable of scale-up (5 gallon quantities to date)
- Treatment shows promise as a field/depot repair product for Dow7, Dow17 and AMS-SAE-M-3171, Type IV Replacement for non painted applications
- Additional work desired on other magnesium alloys with and without additional coatings and in touch-up applications.
- Additional work desired on mixed metal and various magnesium alloy applications

POTENTIAL APPLICATIONS

Develop lightweight corrosion resistant mortar fin assemblies made from magnesium

- Candidate Mg alloys: AZ61B, AZ80, AZ91D, ZK60
- Mortar fins are currently made of aluminum:
- 2014, 2024, 6070 or, 7075 alloys



60mm Mortar:
Replace aluminum boom/fins
with extruded magnesium



Mortar Base Plate:
Replace aluminum
with forged magnesium

Develop corrosion resistant lightweight base plate out of magnesium

- Candidate Mg alloy: AZ80 (die cast or forged billet that will be machined to shape/size)
- Currently made of 7000 series aluminum alloy

Develop improved corrosion resistant magnesium Sabots

- Replace AZ61A with AZ61B and apply an improved coating system



Sabot:
Replace AZ61A magnesium
with AZ61B

Acknowledgements:

- Thanks to Mr. Jeremy Smith and Mr. Charles Benson at Corpus Christi Army Depot (CCAD) for the preparation of Brushed Tagnite test coupons.
- Special Thanks to my associates at NEI Corp., Dr. Fred Allen, Dr. Gaurang Bhargava, Mr. Peter Hornish and Dr. Ganesh Skandan whose efforts on Contract **W15QKN-10-C-0106** made this briefing possible.

Any Questions?

